











## 10.5.2 Inlet Bushing IB-50

**NOTICE**

Use torque wrench with wrench insert and the torques indicated in the torque table (section 13).

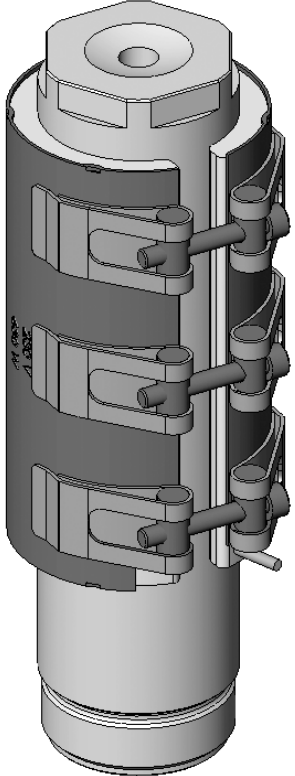
**! WARNING**

	<p><b>Hot Surfaces Hazard</b></p> <p><b>Contact between the skin and hot surfaces could result in burns.</b></p> <p>Use personal protective equipment, such as gloves, apron, sleeves and face protection, to guard against burns.</p> <p>When servicing or handling the hot runner system outside the manifold plates or the injection molding machine, care must be taken to heed the hot surface exposure warnings.</p> <p><b>For first aid contact your medical / safety representing.</b></p>	  
	<p><b>Hazard of Pressurized Air</b></p> <p><b>Pressurized air blow can result in hot plastic or foreign bodies entering the eyes, causing vision damage.</b></p> <p>Use personal protective equipment: Face protection, hearing protection and gloves.</p> <p><b>For first aid contact your medical / safety representing.</b></p>	  



### 10.5.2.1 Technical Data IB-50

In this section the inlet bushing parts are identified with the numbers which are indicated in the following figure.

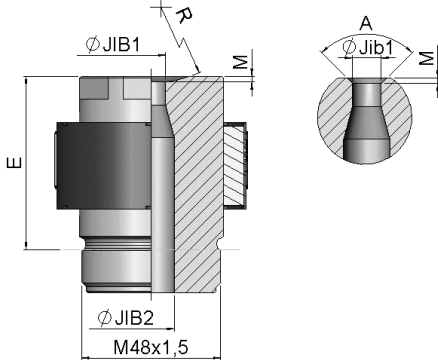


*Doc004750.png*

**General Information**

Inlet Bushing for hot runner systems, installed on manifold.

Can specify the touching shape to Machine nozzle.



*Doc004753.png*

**Specification**

Inlet geometry for the machine nozzle:

Radius (R)	0~50 mm
Angle (AD)	90°~120°

Flow Bore:

ØJIB1	6; 7; 8; ..... 23; 24 mm
ØJIB2	10; 11; 12; ..... 24; 25 mm

Length:

E	25; 50; modifiable 50<E≤200 mm
---	--------------------------------



Service and Maintenance / Color Coding of Thermocouples

<p>Doc004754.png</p>	<b>Inlet Bushing parts IB50 Series</b>			
	<b>Inlet Bushing without Heater</b>			
	No.	Qty.	Description	Item
	(1)	1	Inlet Bushing IB50 Body Version 01 M48X1.5 Modifiable	IB50B02501- MOD
	<b>Inlet Bushing with Heater</b>			
	No.	Qty.	Description	Item
(1)	1	Inlet Bushing IB50 Body Version 01 M48X1.5 Modifiable	IB50BXXX01- MOD XXX=060, 100, 140, 200	
(2)	1	Heater Band ID 50 Version 5 Type J	HB50XXX05 XXX=030; 040; 080; 120	
or	1	Heater Band ID 50 Version 6 Type K	HB50XXX06 XXX=030; 040; 080; 120	

10.5.3 Color Coding of Thermocouples

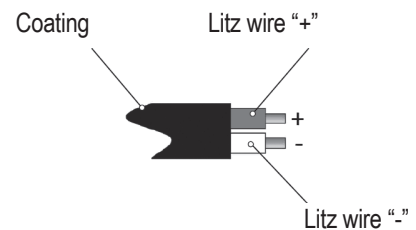
**NOTICE**

Take notice of the production and color identification of thermocouple cables.

Synventive uses J and K type thermocouples. Their color coding is given in the following table:

Table 1: International color coding for thermocouples

Type	International standard IEC 584-3	
J	Black	+ Black
		- White
K	Green	+ Green
		- White

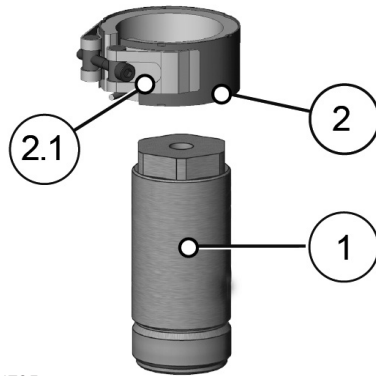


Doc003124.png



### 10.5.3.1 Dismounting and Mounting of the Inlet Bushing on the Manifold

In this section the inlet bushing parts are identified with the numbers indicated in the following figure.



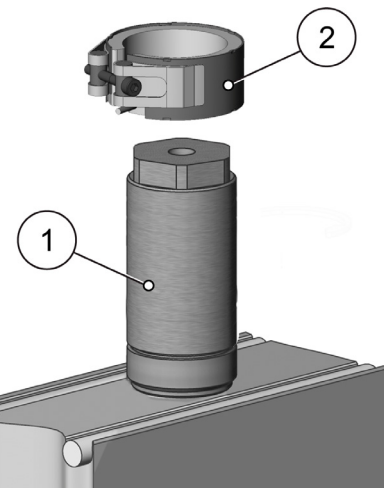
Doc004795.png

#### Inlet Bushing Parts IB-50

Pos.	Qty.	Description	Item
1	1	Inlet bushing body	IB50B###01
2	1	Inlet bushing heater	HB50###
2.1	1	Heater Band J-Type	HB50###5
2.1	1	Heater Band K-Type	HB50###6

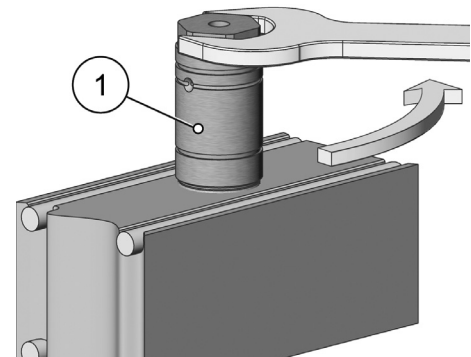
#### Dismounting of the Inlet Bushing IB-50

- 1) Loosen the socket cap screw from the inlet bushing heater (2).
- 2) Lift up the inlet bushing heater (2) from the inlet bushing body (1).



Doc004649.png

- 3) Unscrew the inlet bushing body (1) by using a wrench (HEX46) from the manifold.

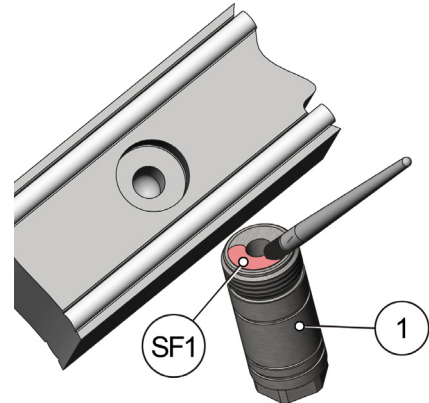


Doc004390.png



## Mounting of the Inlet Bushing IB50

- 1) Apply spotting ink on the inlet bushing body (1) bottom surface (SF1).
- 2) Screw in the inlet bushing body (1) hand-tight into the manifold thread until seated.
- 3) Unscrew the inlet bushing body (1) from the manifold.



Doc004391.png

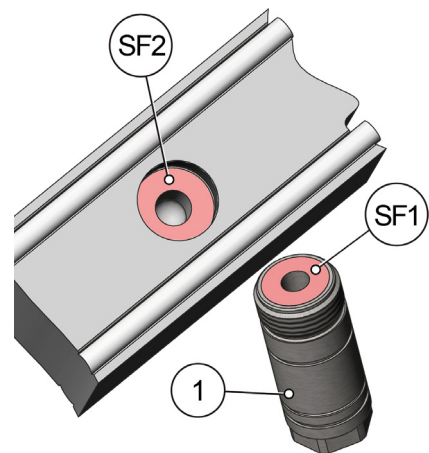
- 4) Check the matching between the manifold bottom surfaces (SF2) and the inlet bushing body (1) surface (SF1).

### NOTICE

The manifold must bear on all surfaces uniformly and flatly, in particular on the inlet bushing body contact face.

In case of any uncertainty, clean the surfaces with a cleaning cloth. If the next ink test is still unsatisfactory, please - contact the Synventive Customer Service or Technical Support.

- 5) With a positive ink test clean the surfaces and proceed to the next step.

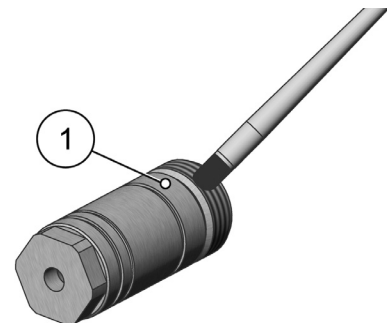


Doc004392.png

- 6) Lubricate the thread (not the face) of the nozzle body with high-temperature assembly paste (anti-seize compound).

### NOTICE

This is an important measure to prevent thread corrosion due to aggressive gases, which could be released during plastics processing.



Doc004393.png

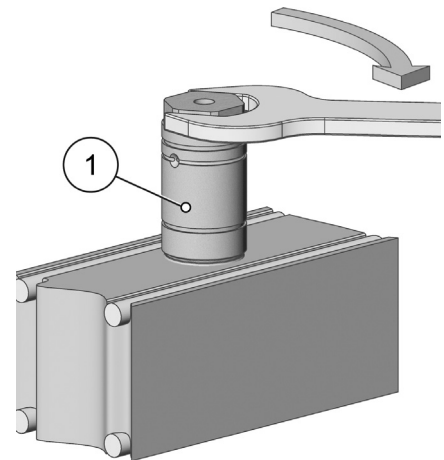


## Service and Maintenance / Color Coding of Thermocouples

- 7) Tighten the inlet bushing body (1) on the manifold.

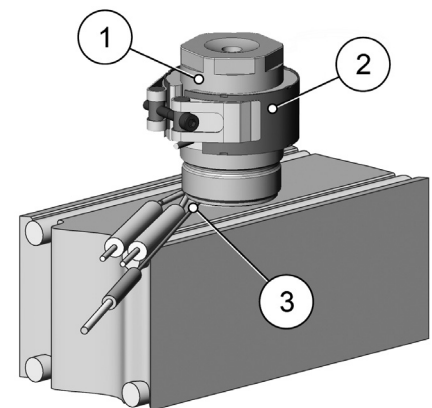
**NOTICE**

Use torque wrench with wrench insert and the torques indicated in the torque table (section 13).



Doc004394.png

- 8) Push the inlet bushing heater (2) along the Inlet bushing body (1).  
9) Tighten the heater (2) at the Inlet bushing body (1) with the socket cap screw.



Doc004658.png